

Alu Tube .312 x .58 wall

Work Order ID 76004

76004

Page 1

November-02-11 4:23:00 PM

ASAP

Item ID: D3681-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacer

Start Date: 02/11/2011 Start Qty: 50.00

50

Cust Item ID:

Required Date: 16/11/2011 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 11/11/02

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3681	Rev A

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA711 & DWG D3681

FOLIO REV: 1A

DWG REV: 1A

2-DEBURR AS REQUIRED

50 φ SL 11/11/10

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

50 φ SL 11/11/10

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

B.A 11/11/10

50 φ SL 11/11/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

November-02-11 4:23:00 PM

76004

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 02/11/2011 **Start Qty:** 50.00

50

Cust Item ID:

Required Date: 16/11/2011 **Req'd Qty:** 50.00

50

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

125

0.00

125

Skidtubes

Memo

0.00

Skidtubes

1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

130

Identify as per dwg & Stock Location: 16 0.00

130

Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

140

OC21- Final Inspection - Work Order Release	0.00
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140

QC

Memo

0.00

Quality Control

21/11/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 76004

76004

Parent Item: D3681-1

D3681-1

Parent Item Name: Spacer

Start Date: 02/11/2011

Required Date: 16/11/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev A new issue 07-10-30 DD verified by:EC
IPP Rev:B Ecn 1056 Rev A dwg DD IPP Rev:C add
seq 125 DD 10.05.03 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.05 8		Purchased		No		100	f	75.1230	0.34	17.89474			

M6061T6T0 3125W 058

ALUM TUBE .3125 x .058w

**

18.000

SL 11/11/10

Location

Loc Qty

Loc Code

MAT013

75.123

116793

1.667

116939

23.972

117400

16.9

118438

32.584

18.000

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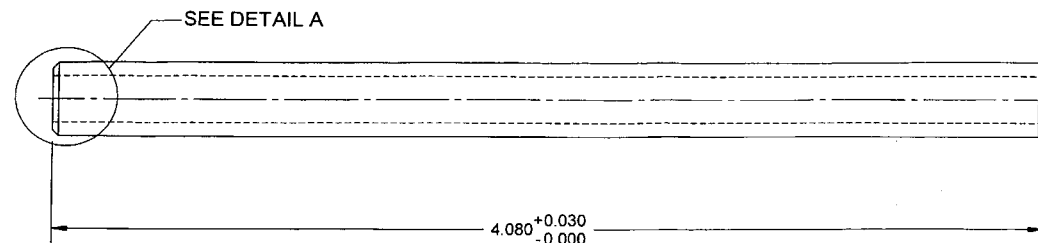
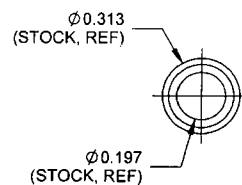
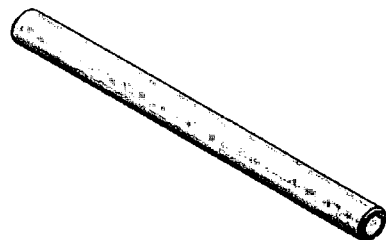
W/O:		WORK ORDER CHANGES					
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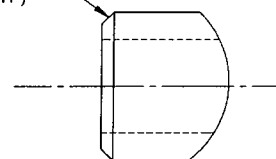


D3681-1 SPACER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 76004 M.L.J
11/11/02

0.025 X 45°
CHAMFER
(TYP)



DETAIL A
(SCALE 4 : 1)

RELEASED
07-11-08

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

A		NEW ISSUE		DC	07.11.08
REV.	DESCRIPTION			BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA			REV. A
DRAWN	SC				DRAWING NO.
CHECKED	SC	D3681			SCALE
MFG. APPR.	SC	TITLE			2:1
APPROVED	SC	SPACER			
DE APPR.	SC	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.			
DATE	07.11.08	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

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